

Work Order ID 57100

March 22, 2010 9:06:52 AM

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Item ID: D4058-041

Revision ID:

Item Name: Ski Section Assembly, Fwd LH

Start Date: 3/22/10 Start Qty: 1.00

Required Date: 3/23/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4058

→ PAT Rev. A

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

110

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1- Assemble as per Dwg D4058-041

2- Use wearplate to locate and to transfer drill holes in ski as per dwg. and use 0.375" unibit to open wearplate mounting holes to finish size.

3 - use wearbar to locate and transfer drill as per dwg. 4 install wear bars.

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Dh 10/03/30 x1

Dh 10/03/30 (x1)

100408

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4058-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Ski Section Assembly, Fwd LH

Start Date: 3/22/10 Start Qty: 1.00



Required Date: 3/23/10 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location:

0.00

Memo

No 57403

0.00

MF 10-4-18

Packaging

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/12

MF

10-4-8

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Picklist Print

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Work Order ID: 57100

Parent Item: D4058-041

Parent Item Name: Ski Section Assembly, Fwd LH


Comments: New Issue 10/03/16 Rev. A DL verified by:DD

Start Date: 3/22/10

Required Date: 3/23/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-6A  Bolt		Purchased	No			100	Each	1,239.000	20.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST356

1239

112720

39

112829

300

112933

300

113149

600

D4058-1

Manufactured

No

100

Each

0.0000

1.0000

Batch. 57098.

Ski Section, Fwd LH

D4067-041

Manufactured

No

100

Each

0.0000

5.0000



Joggled Wearplate

563412

20 Dk 10/03/30

x1 Dk 10/03/30

x5 Dk 10/03/30

AN3C5A BOLT.

MS21043-3 Nut

D4015-041 WEARBAR

M 114108

x

(12)

Dk. 10/03/31

M 112314

x

(12)

Dk. 10/03/31

M 53956

x

(12)

Dk. 10/03/31

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Start Date: 3/22/10

Required Date: 3/23/10

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-4  Nut		Purchased	No			100	Each	725.0000	20.0000			

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST301	685	
112314	100	
112492	11	
113064	174	
114181	400	

20 OK 10/03/30.

NAS1149F0432P

Purchased

No

100

Each

403.0000

20.0000

Washer

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST275	403	
110098	200	
112940	100	
18057	103	

20 OK 10/03/30

March 22, 2010 9:06:51 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149F0463P  Washer		Purchased	No			100	Each	229.0000	20.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST275

229

108246

29

114223

200

20 DL 10/03/30

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Shop Packet Print

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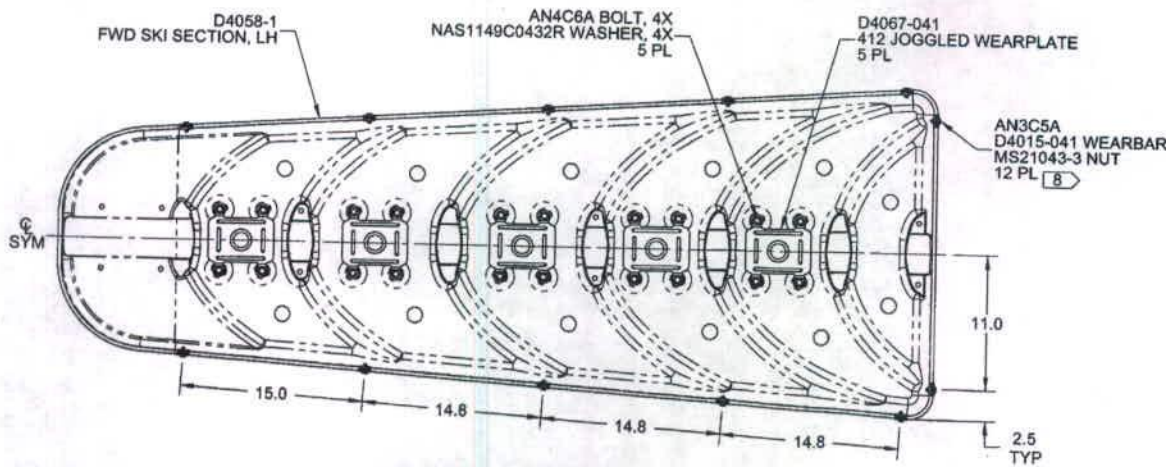
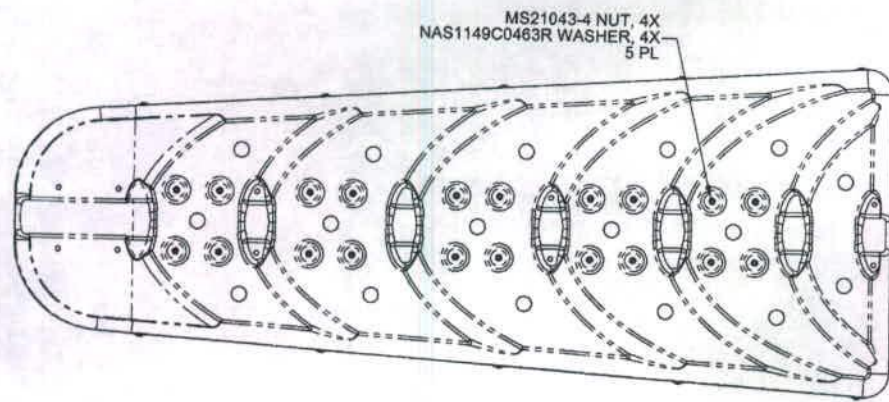
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D4058-041 FWD SKI ASSY, LH

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4058-041	FWD SKI ASSY, LH
2	12	D4015-041	WEARBAR
3	1	D4058-1	FWD SKI SECTION, LH
4	5	D4067-041	412 JOGGLED WEARPLATE
5	12	AN3C5A	
6	20	AN4C6A	BOLT
7	12	MS21043-3	NUT
8	20	MS21043-4	NUT
9	20	NAS1149C0432R	WASHER
10	20	NAS1149C0463R	WASHER

W/O 57100

RELEASED
2010-04-07
W/O

- D4058-041 NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 28.5 lbs
 8) LOCATE D4015-041 (ITEM 2) AS SHOWN. TRANSFER DRILL Ø0.191" HOLE FROM D4015-041 TO D4058-1. CHAMFER HOLE 0.03 X 45°. FASTEN USING PRESCRIBED HARDWARE
 9) TORQUE: AN3 NUTS = 15-20 in-lb
 AN4 NUTS = 50-70 in-lb

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4058	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 6
APPROVED		FWD SKI ASSY	SCALE
DE APPR.			NTS
DATE	10.03.31	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

